

V-30 DUAL SHUTOFF VALVE

FOR ARGON AND WATER



These INSTRUCTIONS are for experienced operators. If you are not fully familiar with the principles of operation and safe practices for arc welding equipment, we urge you to read our booklet, "Precautions and Safe Practices for Arc Welding, Cutting and Gouging," Form 52-529. Do NOT permit untrained persons to install, operate, or maintain this equipment. Do NOT attempt to install or operate this equipment until you have read and fully understand these instructions. If you do not fully understand these instructions, contact your supplier for further information.

I. INSTALLATION

Argon pressure in this valve should never exceed 25 psi and water pressure should never exceed 75 psi.

1. Fasten the valve securely to the bench with two 1/4-in. bolts or lag screws.
2. Insert the lever extension in the valve lever and fasten with the setscrew.
3. Apply a single turn of either 3/16-in. or 1/4-in. Teflon tape to the pipe threads on all hose connection fittings. Screw one 11N16 connection (L.H. fitting w/ annular vee groove) into valve opening marked 'water', and screw the other 11N16 into the opening directly opposite. Screw one 74S76 connection (R.H. fitting w/o groove) in valve opening marked 'argon' and screw the other 74S76 into the opening directly opposite. Tighten all connections with a wrench.
4. Connect the argon supply and torch hoses to the inlet and outlet connections marked 'argon'.
5. Similarly connect the water hoses to the connections marked 'water'.

II. MAINTENANCE INSTRUCTIONS

If leakage occurs through either valve, readjust the valve setting. To do this: Hold the lever in the full-down position and backoff the adjusting screws in the lever until both valves just leak (equally). Then alternately turn the screws down (clockwise) a fraction of a turn at a time until both valves just seal off. At this point, give each screw an additional 1/8 turn. If the leak is still present, the leaking valve seat must be cleaned or replaced.

If leakage occurs around the valve stem at the top of the valve, the valve o-rings need replacement. To correct either condition proceed as follows:

1. Close the argon cylinder valve and the water sup-

ply valve. Momentarily raise the valve lever to release any pressure from the hose lines. Then release the pressure-adjusting screw of the argon regulator.

2. Loosen the setscrew at the hinge end of the lever and remove the hinge pin and lever.
3. Unscrew retaining nut containing valve stem o-rings and washers and remove from unit.
4. Remove the valve spring. Remove valve stem extension, guide bushing, valve stem body, and valve seat. Remove valve opening spring. Wipe seating surface in valve body with clean cloth and examine the seat to see whether it is nicked or marred. If it is badly marred, the valve might leak when reassembled. In case it does leak, the valve should be returned to the factory for reseating.
5. Replace the valve opening spring.
6. Examine the rubber seat and if it is damaged, the valve seat should be replaced.
7. Examine the upper end of the valve stem extension where it passes through the o-rings.
8. Replace the valve seat and place the valve stem body into the valve seat.
9. Slide the guide bushing onto the valve stem body, and place the valve stem extension into the valve stem body. To prevent binding apply silicone grease, P/N 17672 (1 oz. tube), to the extension.
10. Replacement the valve stem packing spring.
11. Replace and tighten the retaining nut and o-rings in the valve. Lightly lubricate the o-rings with silicone grease.
12. If leakage occurs past the valve stem extension and o-rings, unscrew retaining nut and replace the valve packing in the cap bushing as follows: Remove the o-rings and bronze washers. Replace, in reverse order, with four new o-rings. Replace the bronze washer.
13. Adjust valve setting as described in the first paragraph.
14. Test for leakage.

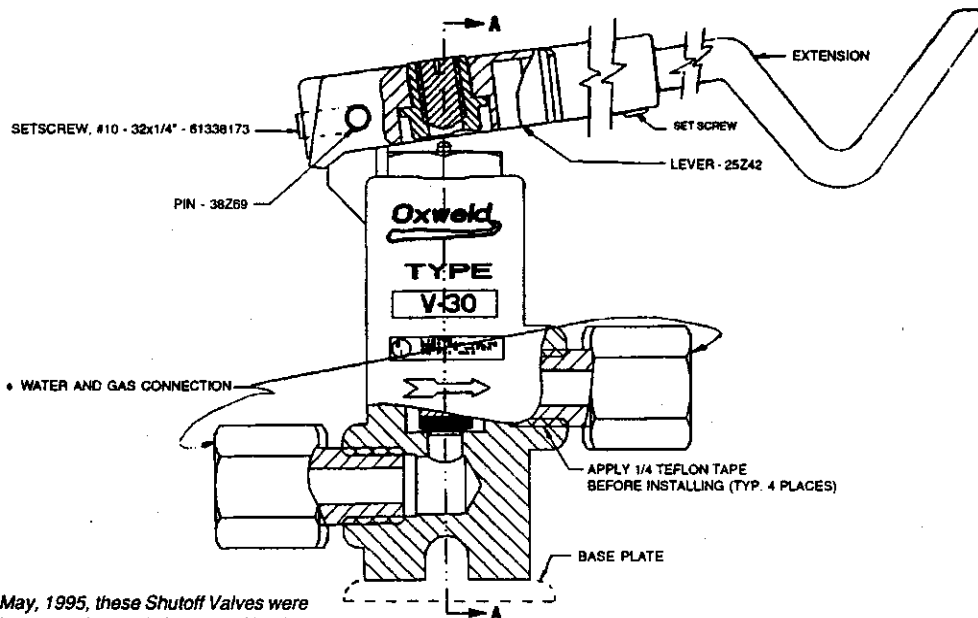
**Be sure this information reaches the operator.
You can get extra copies through your supplier.**



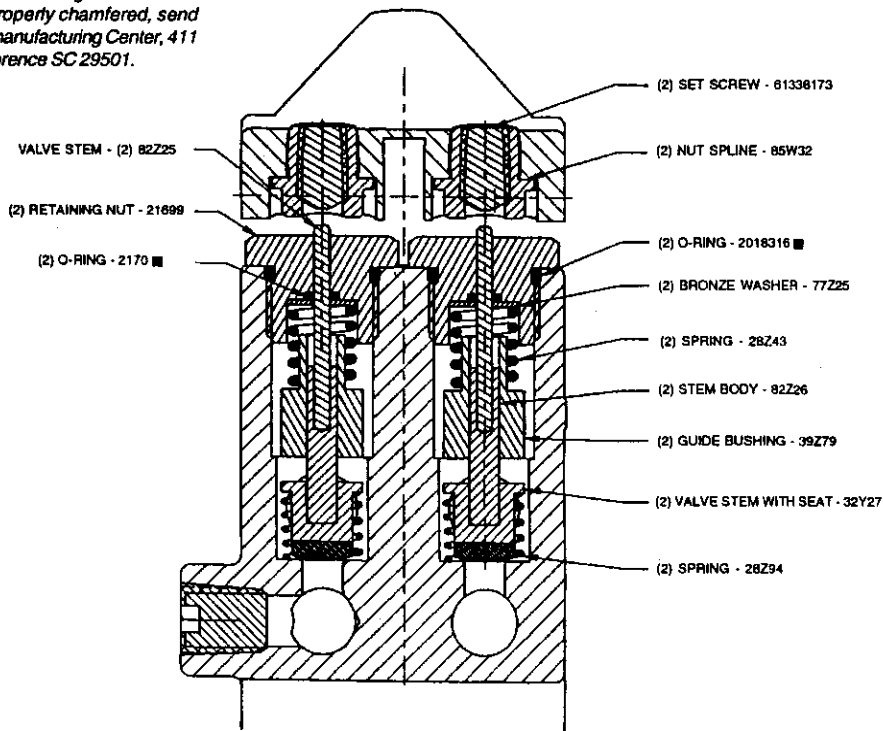
**ESAB Welding &
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REPLACEMENT PARTS

The following drawing shows all replacement parts available for the V-30 valve. To order, identify the required parts from the drawing and specify by part number and name.



NOTE: Starting May, 1995, these Shutoff Valves were modified to use o-ring seals in place of leather packing washers. Parts are interchangeable with the old construction, but the valve body must be chamfered for effective o-ring seal. To have your old valve body properly chamfered, send the valve to ESAB Remanufacturing Center, 411 S. Ebenezer Road, Florence SC 29501.



■ Lightly lubricate o-rings with silicone grease, P/N 17672 (1 oz. tube)

V-30 Dual Shutoff Valve, Part No. 16X21

♦ PARTS SUPPLIED UNASSEMBLED

QTY	PART NO.	DESCRIPTION
2	11N18	Water Connection
2	74S78	Argon Connection
1	77Z26	Base Plate
1	77Z31	Lever Extension
1	6123-9907	Set screw
4		Screw, No. 10—24 x 1/2"
4		Lockwasher, No. 10

HARDWARE

Part No.	Description
6133-8173	5/16-in.-24 x 1/2-in. Lg. Headless, Setscrew
6123-9907	No. 10—32 x 3/16-in. Lg. Headless, Setscrew
6133-0908	No. 10—32 x 1/4-in. Lg. Headless, Setscrew

